

Date: Tuesday, 7/10/2007 1:06:27 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
Job Number : 33460
Estimate Number : 10532
P.O. Number :
This Issue : 7/10/2007 S.O. No. :
Prsht Rev. : NC Part Number : K10003
First Issue : / / Type : SMALL /MED FAB Drawing Number : IIN D205-634 REV D
Previous Run : 33039 Drawing Revision : D
Material :
Due Date : 7/17/2007 Qty: 10 Um: Each
Written By :
Checked & Approved By :
Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011
KJ/RF
Est : J 06-07-25 As per DSI 9344
JLM
Est : K 06.11.17 Per K10003 Rev C
KJ
Est Rev: L 07.01.12 Document Record for copying bluefile rmv
KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 005

(24. 340.24)

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch
24 D2570 Bushing

125
32103

SP

146
33468

4.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty Part Number Description Batch
1 D2571 Saddle

4
1531647

6

31719, 7/8/7 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE KIT

Job Number: 33460

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	31648

SP

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	31717

3 SP
31721

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	31718

6 SP
31722

8.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	31225

6 SP
32511

9.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	31226

7/8/8 SP

W/O:		WORK ORDER CHANGES					
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Drawing Name: SADDLE KIT

Job Number: 33460

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Set Screw

Pick:

Qty

Part Number

Description

Batch

4

D2747

Socket Head Set Screw

36
B31300

4
M33470

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2876

Spacer

B31227

SP

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2877

Spacer

B30055

SP

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tow Ring

Pick:

Qty

Part Number

Description

Batch

1

D2968-041

Tow Ring

29834

SP

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Set Screw

Batch:

B28093

SP

15.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Bolt

Pick:

M103922

2/8/2 SP

W/O:		WORK ORDER CHANGES					
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Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

HTT 16.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	

HTT 17.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	

HTT 18.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	

HTT 19.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 320.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	

HTT 20.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	

HTT

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

1

AN970-4

Washer

M103344

SP

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 290.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

1/29

MS21042L4

Nut (or MS21042-4)

M102552

1/8/13 50

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

CP 07/08/13 X10 Kits

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

REV: H

CP 07/08/13 (10)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.14

Job Completion



0207/08/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33460

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